

MANUFACTURE OF PROJECTION NUT AND ITS FORMING DIE

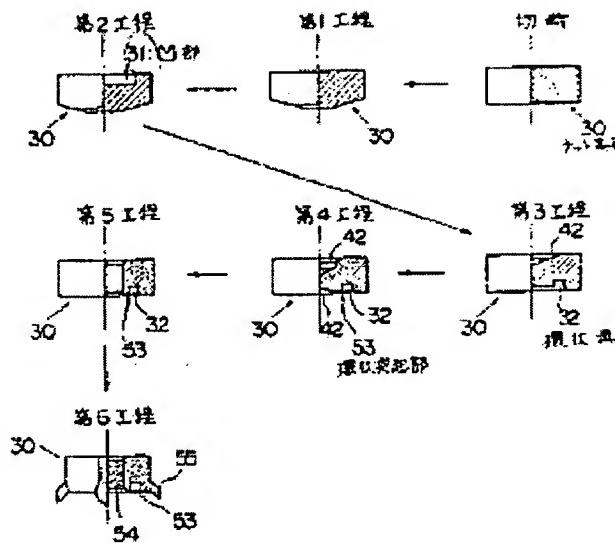
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Abstract of JP1127135

PURPOSE: To satisfactorily form an annular projection and to improve a die life by forming a recessed part in advance on one end face of a nut material and projecting an excess metal at the center part of the recessed part by inserting the annular projection for forming a groove into the recessed part thereof.

CONSTITUTION: A nut material 30 is stored in a die, pressurized by a punch and a recessed part 31 is formed on the lower face and when it is stored in a die by reversing upside down, the annular projection for groove forming is fitted to the recessed part 31 and when a material 30 is pressurized by a punch, the projection part for forming a prepd. hole is bitten into the material 30 and the excess metal is projected to the recessed part 31. The excess metal then fills up the inner peripheral side of the annular projection for forming a groove and the part of the groove forming annular projection remains as an annular groove 32. A prepd. hole 42 is also formed on the material 30. An annular projection part 53 is formed according to the formation of the annular groove 32 on the lower face center part of the material 30 and when the center part of the material 30 is punched by utilizing the prepd. hole 42, the projection part 53 becomes in a complete shape. A screw hole 54 is made by executing tapping on this punched part and a projection 55 is made by executing extruding on the angle of the outer periphery.



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